

# PATENT ABSTRACTS OF JAPAN

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(71)Applicant : MITSUBISHI CHEM CORP

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(72)Inventor : IWADE HITOSHI

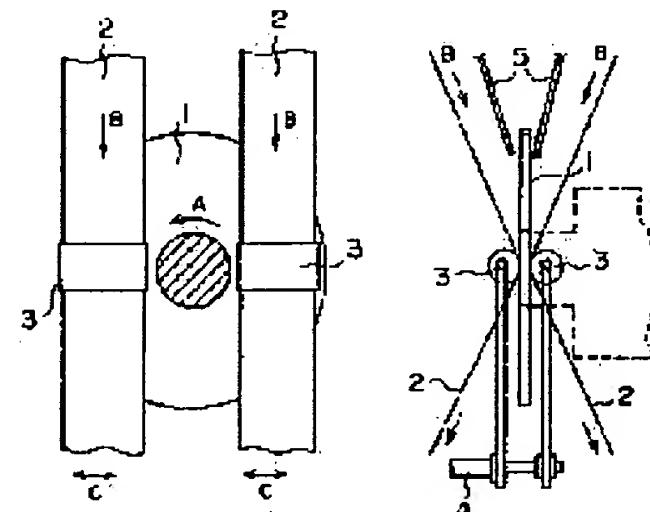
MORINAGA MUNEAKI

## (54) MANUFACTURE OF MAGNETIC RECORDING MEDIUM

### (57)Abstract:

**PURPOSE:** To obtain a magnetic disc having excellent characteristics of a head and excellent CSS characteristics by a method wherein, after a texture process is applied to a substrate surface under specific conditions, a magnetic layer is formed.

**CONSTITUTION:** A disc-type substrate 1 is made to rotate in the direction of an arrow A. While the substrate 1 rotates, 4 polishing tapes 2 are pressed against both the surfaces of the substrate 1 by contact rollers 3 to polish the substrate 1 surfaces. The roller 3 presses the tape 2 against the surface of the substrate 1 with a fixed force given by a roller pressing cylinder 4. The tape 2 is made to run in the direction of an arrow B under the condition that the circumferential speed at the innermost circumference is not less than 0.25m/sec. and a new tape surface is always brought into contact with the surface of the substrate 1 for polishing. Further, the tapes 2 are made to vibrate in the directions of arrows C by the reciprocal movements of the rollers 3 to polish the whole surfaces of the substrate 1 and so as to have angles  $\theta$  with which polishing tracks A formed on the substrate 1 by the tapes 2 cross each other 10-40°. Further, polishing solution which is the suspension of free polishing grains is supplied to the polishing surface sides of the tapes 2 by nozzles 5. After this texture treatment, protrusions such as burrs and turned-up edges are removed and a metal magnetic thin film is formed by sputtering, etc., to obtain a



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magnetic disc.

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